

Work Order ID 129536

129536

Page 1

Friday, February 13, 2015 10:53:54 AM

Item ID: D3294-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket For Interior Window For -115
 Start Date: 2/13/2015 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 2/13/2015 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 15-02-13 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3294	D								

100 0.00
 100
 Waterjet (7) _____ DC15/02/18

FLOW CNC Waterjet
 Memo
 1-Cut as per Dwg D3294
 CUt File D3294-3
 Dwg Rev: D
 Prog Rev: D
 *grain direction on a 45 deg as per dwg**
 2-Deburr if necessary

110 0.00
 110
 QC (7) _____ DC15/02/18

Quality Control Memo 0.00

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Friday, February 13, 2015 10:53:54 AM

1 29536

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 2/13/2015 **Start Qty:** 8.00 ***g***

Cust Item ID:

Required Date: 2/13/2015 **Req'd Qty:** 8.00 ***Q***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Chemical Conversion Coat per QSI005 4.1

0.00

150

0.00

HandFinish

Memo

Hand Finishing

QC7-Inspect Chemical Conversion Coat

0.00

160

0.00

QC

Memo

Quality Control

0.00

170

0.00

Small Fab

Memo

Small Fab

1-Install D3294-5 doubler to D3294-3 bracket with rivets as per dwg. D3294

DAS

38

0-89

MAR 05 2015

DA

2A

9.99

7AS

36

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Equip/Tooling									
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Work Order ID 129536

129536

Page 5

Friday, February 13, 2015 10:53:54 AM

Item ID: D3294-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Bracket For Interior Window For -115
Start Date: 2/13/2015 Start Qty: 8.00 *8* Cust Item ID:
Required Date: 2/13/2015 Req'd Qty: 8.00 *8* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>SH-13</u>	0.00							
210									
Packaging	Memo	0.00							
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

7 MAR 18 2015 DAS
088

MLD 15-03-19

ME
15-3-18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☒ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____

Picklist Print

Friday, February 13, 2015 10:53:58 AM

Page 1

Work Order ID: 129536

129536

Parent Item: D3294-1

D3294-1

Parent Item Name: Bracket For Interior Window For -115

Start Date: 2/13/2015

Required Date: 2/13/2015

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP A04.08.24New issueKJ/JLM
IPP Rev:B Now On Waterjet 07-03-26 JLM
IPP Rev:C 08-07-16 Redesign part DD verified by:EC
IPP Rev:D 08-10-06 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.080

Purchased

No

100

sf

196.8161

1.8

16

M2024T3S 080

2024-T3 .080 sheet

**

2/15/02/14

Location

Loc Qty

Loc Code

MAT021

196.8161

M127668

10.5

M129584

18.3161

M129891

168

28

D3294-5

Manufactured

No

170

Each

15.0000

1

8

D3294-5

Doubler

**

15/03/05 DAS 36 9-89

Location

Loc Qty

Loc Code

GA

15

120378

7

121566

8

7

MS20470AD4-5

Purchased

No

170

Each

2,496.000

15

120

MS20470AD4-5

RIVET, UNIVERSAL HEAD

**

15/03/05 DAS 36 9-89

Location

Loc Qty

Loc Code

GA

2248

m128401

2216

m128813

32

ST310

248

m128813

248

105

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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DART AEROSPACE LTD		Work Order:	129536
Description: Bracket Assembly		Part Number:	D3294-1
Inspection Dwg: D3294	Rev: D	Page 1 of 1	

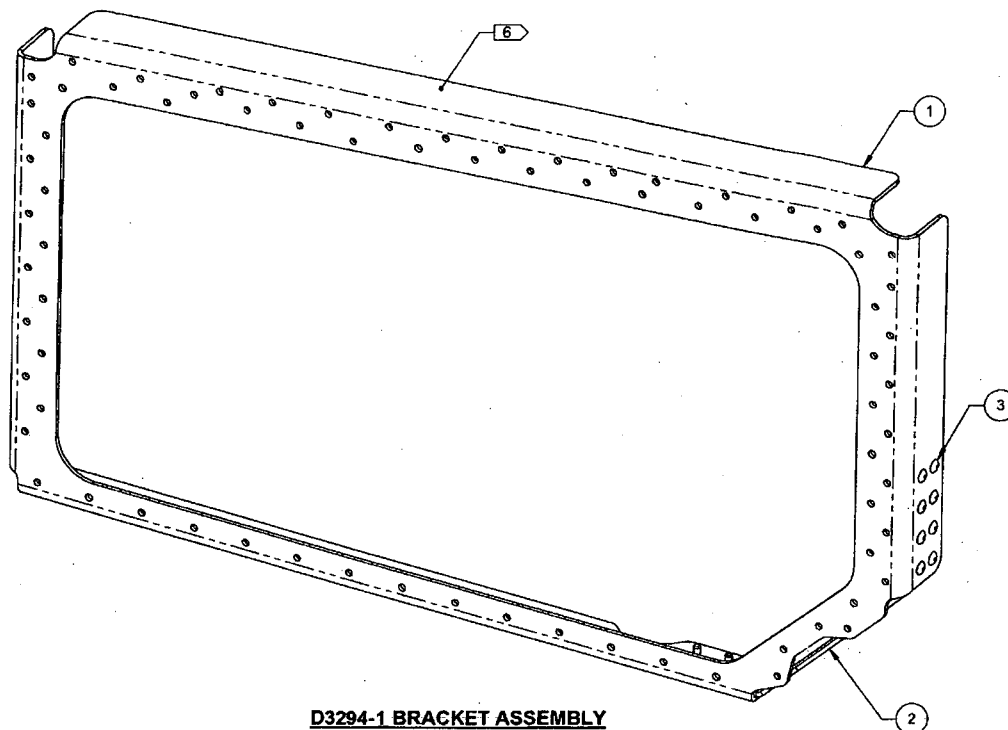
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	Ø .129	✓			
Ø0.141	+0.005/-0.001	Ø .140	✓			
6.708	+/-0.010	6.708	✓			
1.118	+/-0.010	1.117	✓			
5.590	+/-0.010	5.593	✓			
1.118	+/-0.010	—	—	—	—	—
13.563	+/-0.010	13.563	✓			
1.043	+/-0.010	1.044	✓			
0.625	+/-0.010	.625	✓			
0.325	+/-0.010	.322	✓			
0.300	+/-0.010	.300	✓			
0.400	+/-0.010	.400	✓			
6.000	+/-0.010	6.001	✓			
1.000	+/-0.010	.999	✓			
17.124	+/-0.010	17.124	✓			
16.13	+/-0.030	16.13	✓			
7.27	+/-0.030	7.271	✓			
11.97	+/-0.030	11.97	✓			
8.37	+/-0.030	8.367	✓			
20.05	+/-0.030	20.05	✓			
12.98	+/-0.030	12.98	✓			
14.59	+/-0.030	14.59	✓			
11.66	+/-0.030	11.66	✓			
0.080	+/-0.010	.080	✓			

Measured by:	DA	Audited by:	36	Preliminary Approval:	
Date:	15/02/18	Date:	FEB 20 2015	Date:	

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	
F	13.05.08	Dwg Rev updated	KJ	

ITEM	QTY	P/N	DESCRIPTION
	X	D3294-1	BRACKET ASSEMBLY
1	1	D3294-3	BRACKET
2	1	D3294-5	DOUBLER
3	15	MS20470AD4-5	RIVET



D3294-1 BRACKET ASSEMBLY

NOTES:

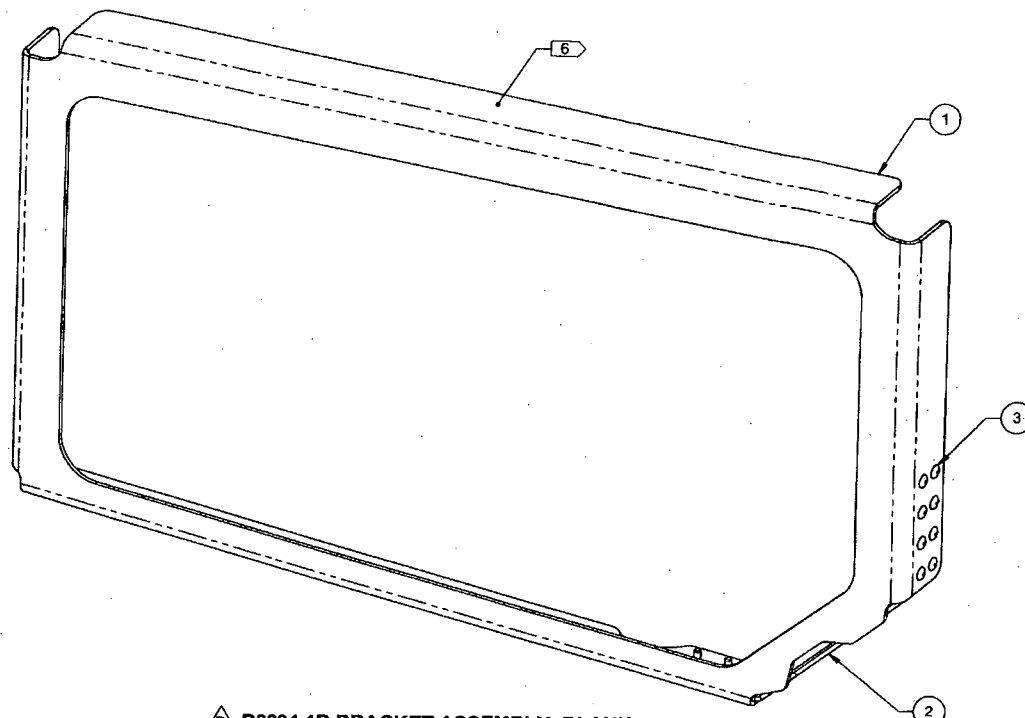
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1" PER DART QSI 044 6.1
- 7) WEIGHT: 0.83 lbs

UNCO
SUBJECT
WAT
NO. 129536 MCL
1502-13

RELEASED
2012-11-21

REV.	DESCRIPTION	BY	DATE
D	ADD D3294-1B/-3B/-3FB. REASON: PAR12-223.	MB	12.11.15
C	REMOVE FLANGE PREVIOUSLY ADDED. ADD -5 DOUBLER ZN A4-1, SHEET 5+6	HS	09.03.24
B	CHANGE FLANGE FROM OUTSIDE TO INSIDE, ZN B4-1, C3-2. CHANGE GRAIN DIRECTION, ZN C4-2	HS	08.09.22
A	NEW ISSUE	CP	04.06.28
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3294 TITLE BRACKET DATE 12.11.15		
DRAWN			
CHECKED			
MFG. APPR.			
DE APPR.			
DATE	12.11.15	SCALE	NTS
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ITEM	QTY -1B	P/N	DESCRIPTION
	X	D3294-1B	BRACKET ASSEMBLY, BLANK
1	1	D3294-3B	BRACKET
2	1	D3294-5	DOUBLER
3	15	MS20470AD4-5	RIVET



D3294-1B BRACKET ASSEMBLY, BLANK

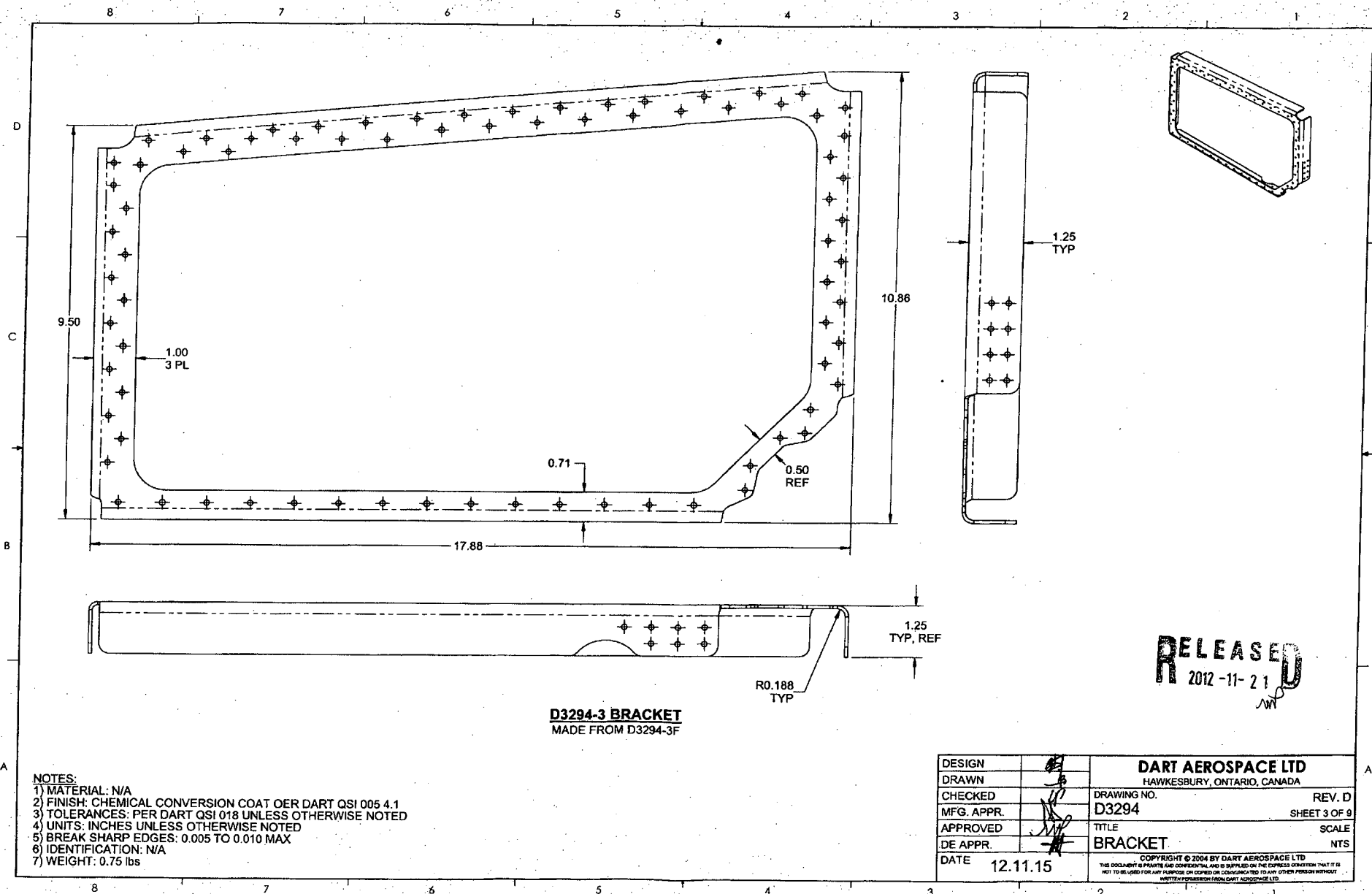
RELEASED
2012-11-21

NOTES:

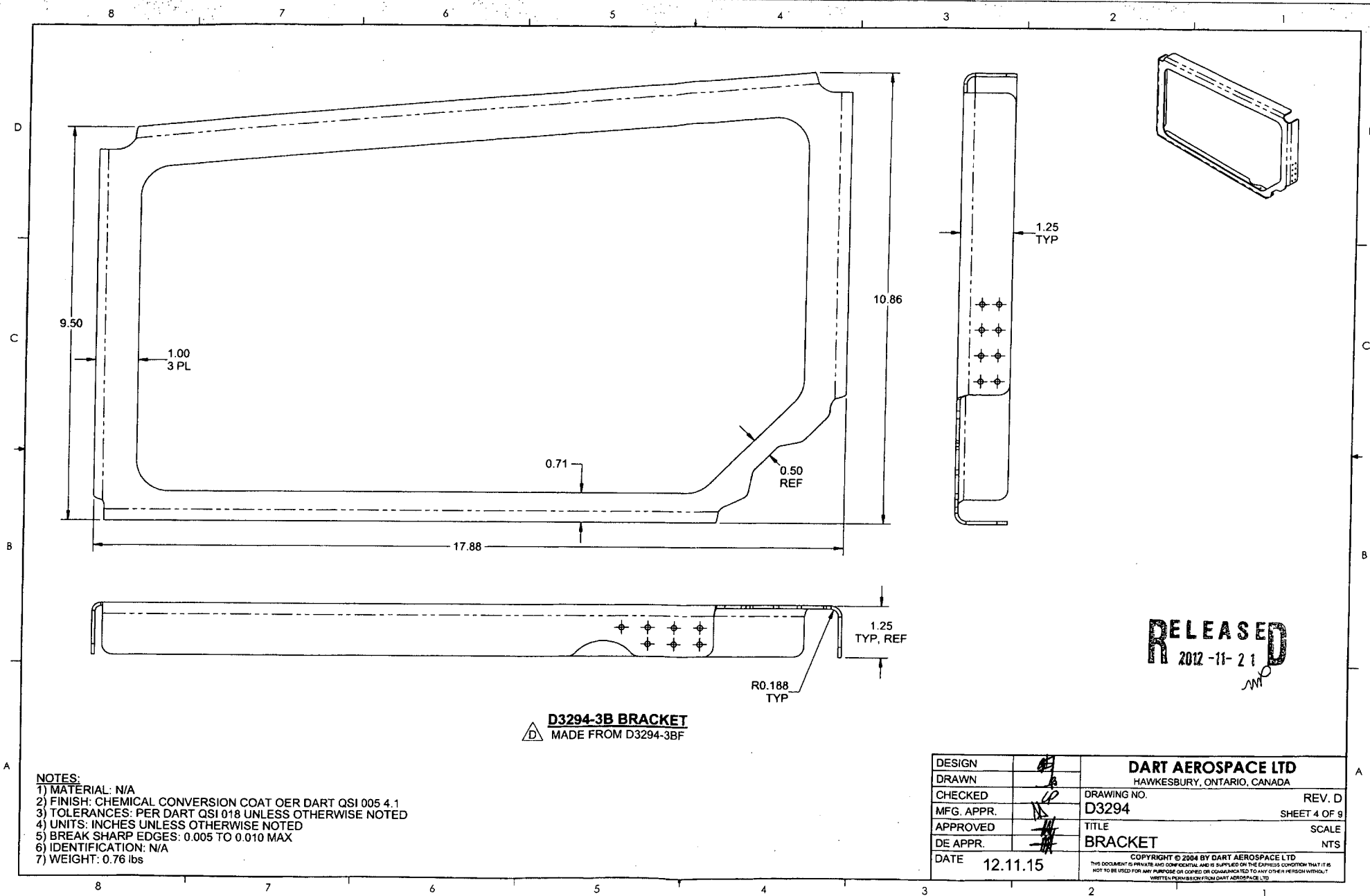
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1B" PER DART QSI 044 6.1
- 7) WEIGHT: 0.83 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3294	REV. D
MFG. APPR.		TITLE BRACKET	SHEET 2 OF 9
APPROVED		SCALE	NTS
DE APPR.		DATE 12.11.15	

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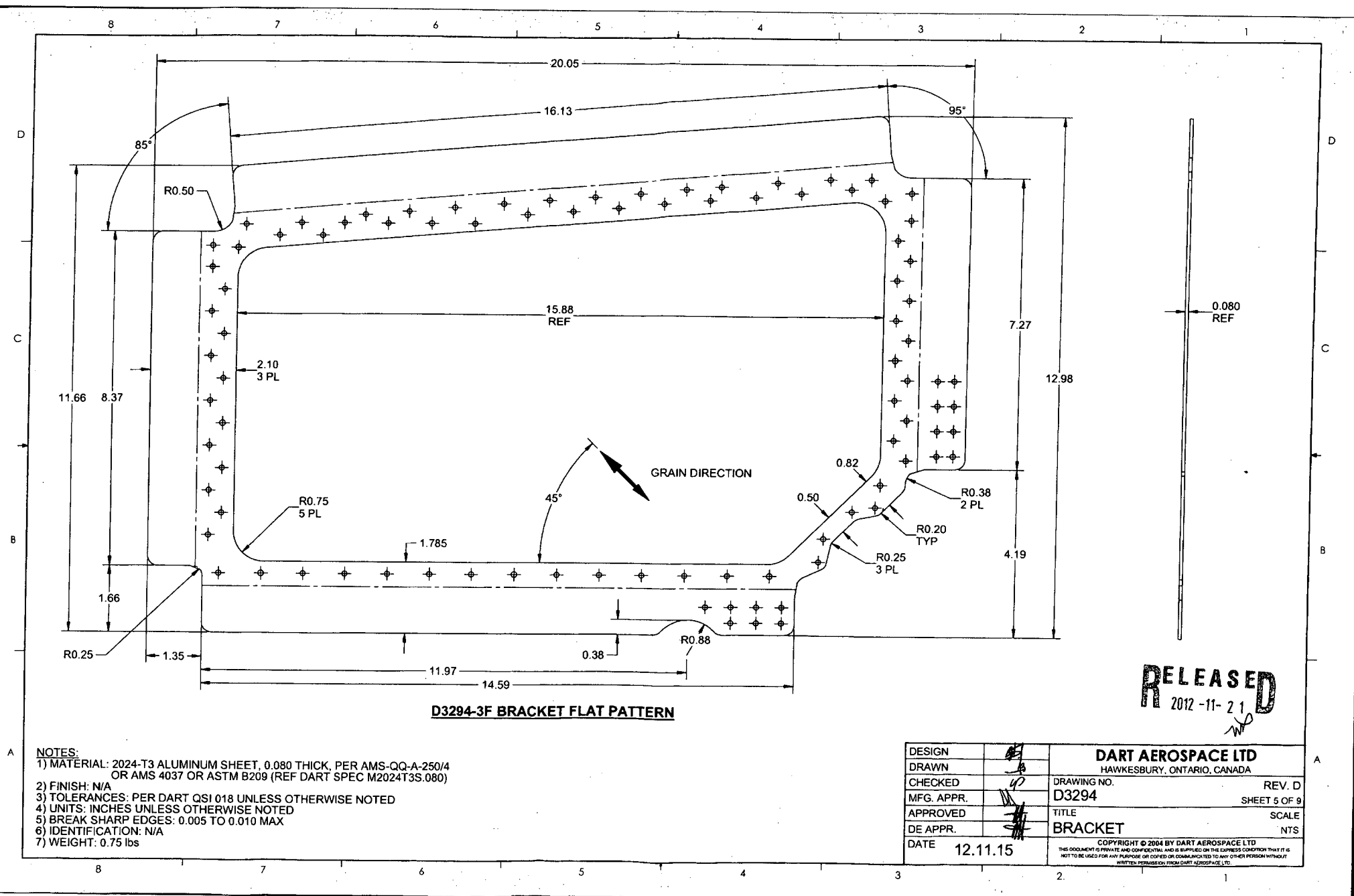


RELEASED
 2012-11-21



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT OER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.76 lbs

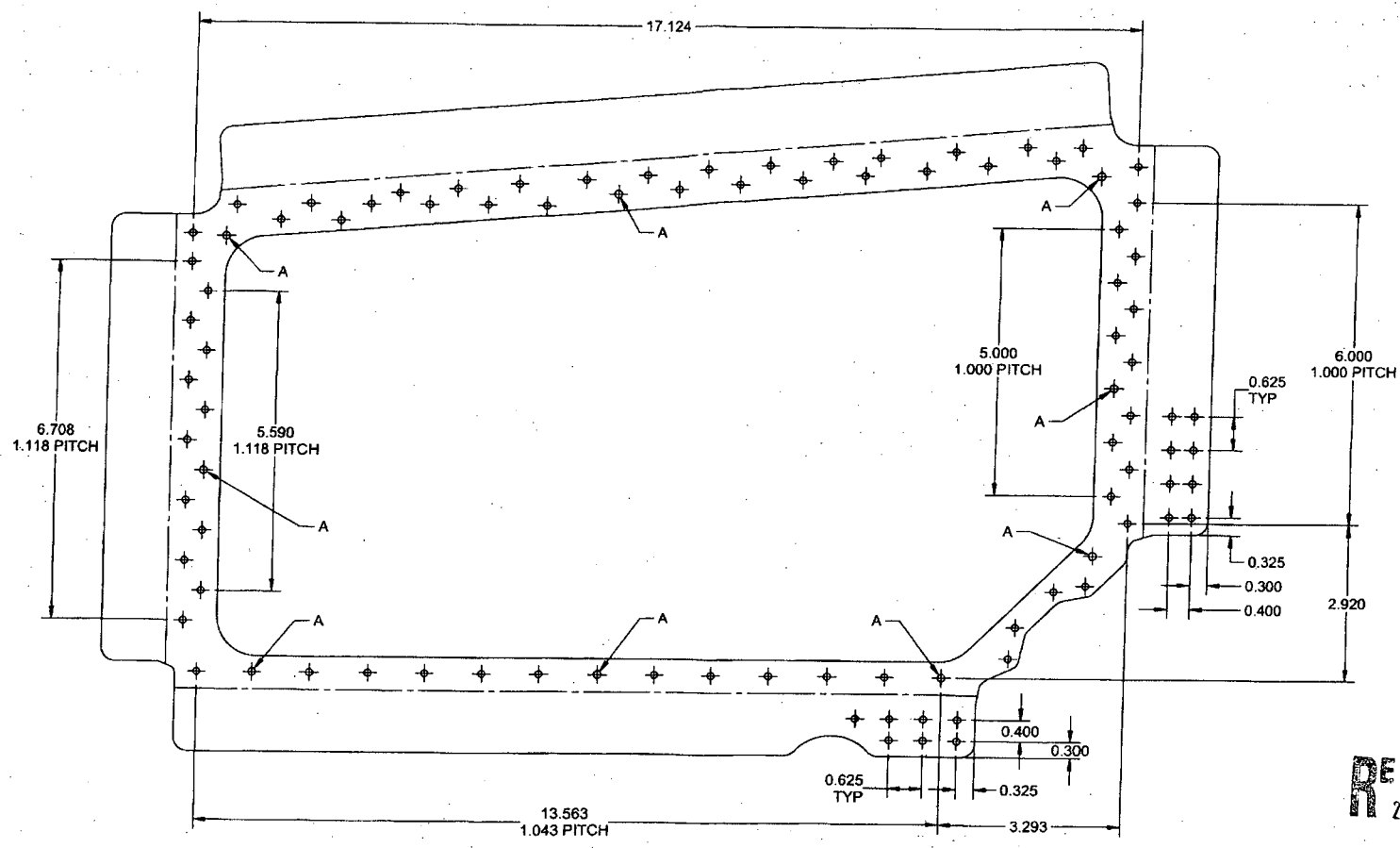
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3294	SHEET 4 OF 9
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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2012-11-21

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.080)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.75 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3294	SHEET 5 OF 9
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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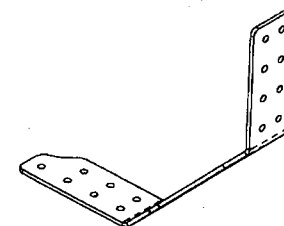
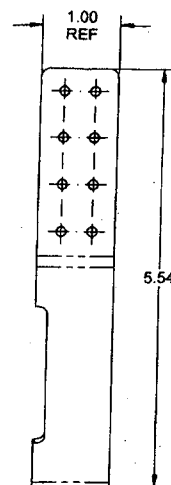
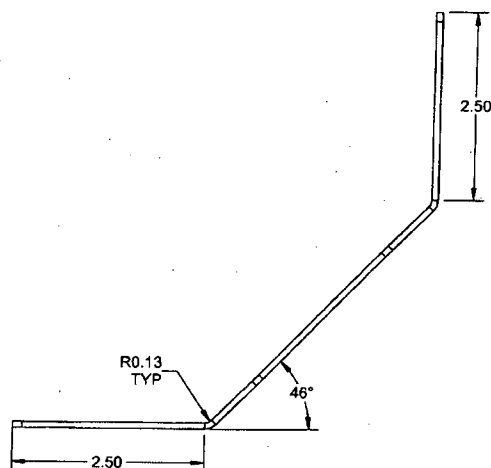
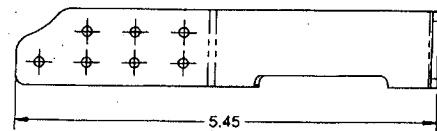


RELEASED
2012-11-21

LABEL	HOLE Ø
ALL HOLES UNLESS NOTED	0.129
A	0.141

D3294-3F BRACKET FLAT PATTERN
SUPPLEMENTAL VIEW

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3294	REV. D
MFG. APPR.			SHEET 6 OF 9
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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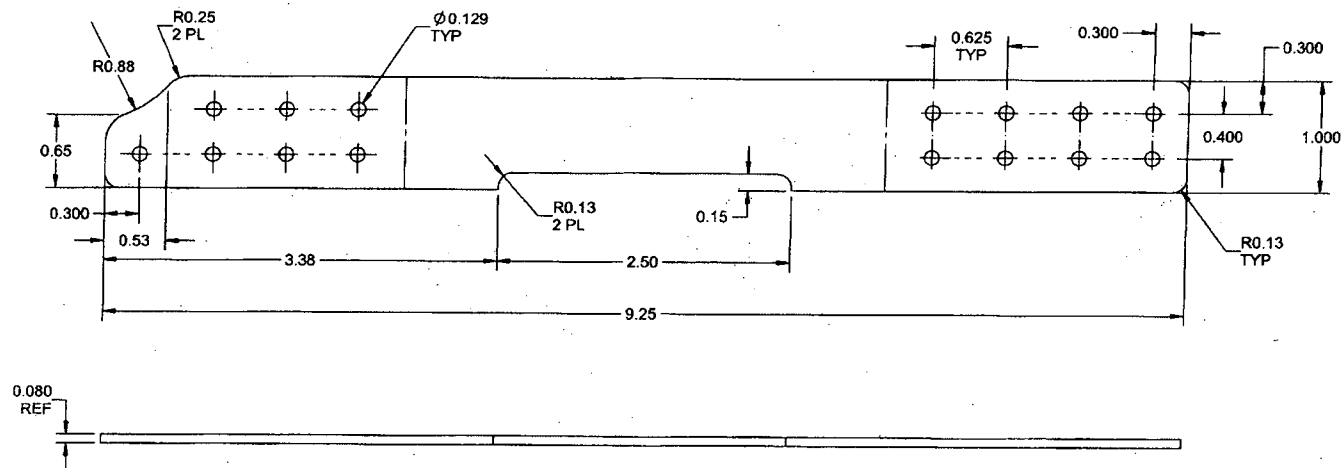
D3294-5 DOUBLER
MADE FROM D3294-5F

RELEASED
2012-11-21

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3294	REV. D
MFG. APPR.		TITLE	SHEET 8 OF 9
APPROVED		BRACKET	SCALE
DE APPR.			NTS
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D3294-5F DOUBLER FLAT-PATTERN

RELEASED
2012-11-21

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.080)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3294	REV. D
MFG. APPR.			SHEET 9 OF 9
APPROVED		TITLE BRACKET	SCALE
DE APPR.			NTS
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